

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024224**Date Inspected:** 01-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

**Trial Assembly**

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhang Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13BE

PCMK: AH3151

Weld No: 075

Welder: 044772

WPS-B-P-2114-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhang Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

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Components; OBG  
PCMK: SA6002C  
Weld No: 005,006  
Welder: 069469  
WPS-B-T-2232-ESAB

Components; OBG  
PCMK: SA6003C  
Weld No: 005,006  
Welder: 069469  
WPS-B-T-2232-ESAB

Components; OBG  
PCMK: SA6003D  
Weld No: 007,008  
Welder: 069469  
WPS-B-T-2232-ESAB

Components; OBG  
PCMK: SA3128B  
Weld No: 004~006  
Welder: 055564  
WPS-B-T-2232-ESAB

This QA Inspector observed the following work in progress for Trial Assembly.  
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.  
ZPMC QC is identified as Wang Xiang Pin.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

Components; OBG 13AE  
PCMK: SEG3007AH  
Weld No: 063  
Welder: 200113, 068859  
WPS-B-P-2114-TC-U4b-FCM-1

Components; OBG 14W + 13CW  
PCMK: DP3148-001  
Weld No: 275  
Welder: 067275  
WPS-B-P-2114-TC-U4b-FCM-1

Components; OBG 14W + 13CW

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PCMK: DP3172-001  
Weld No: 017  
Welder: 067275  
WPS-B-P-2114-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly.  
ZPMC was using the Flux Core Arc Welding (FCAW) process.  
ZPMC QC is identified as Wang Xiang Pin.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

Components; OBG 13AW  
PCMK: SA6003A  
Weld No: 003,004  
Welder: 069469  
WPS-B-T-2231-ESAB

Components; OBG 13AW  
PCMK: SA6004A  
Weld No: 003,004  
Welder: 069469  
WPS-B-T-2231-ESAB

This Caltrans QA Inspector performed a pre-blast visual inspection in OBG13AE. This inspection included the bottom surface of Deck Plates DP3073, DP3074, DP3075, DP3076, and approximately 1500mm of the top sides of all Floor Beams and Diaphragms between Panel Point 119 + 1500 through 120 and Longitudinal Diaphragm LD3025A through Longitudinal Bulkhead SA3093A. Surface defects and base metal surface irregularities that required grinding were marked up with colored chalk, and weld defects that require welding were taped with gray masking tape for repair after the coating has been applied. ZPMC QC and ABF inspection personnel were present during the inspection and informed of QA findings. (see photos)

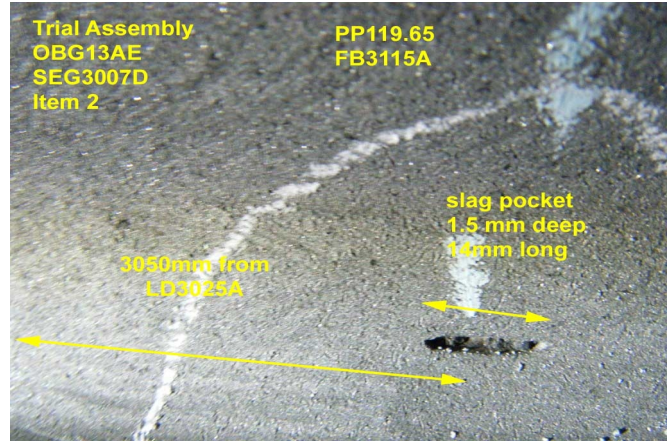
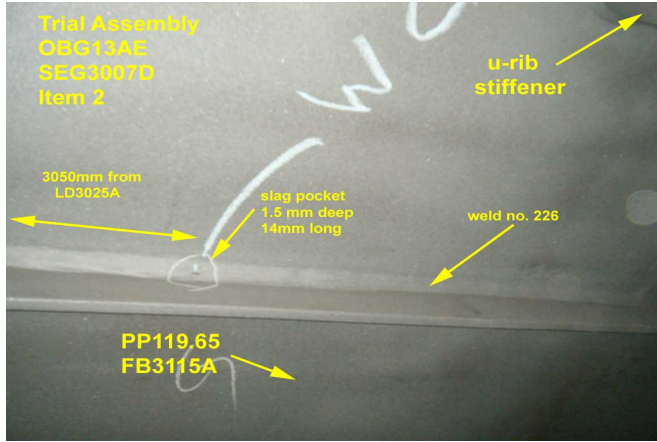
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## Summary of Conversations:

“No relevant conversations.”

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

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**Inspected By:** Leavitt, Kelly

Quality Assurance Inspector

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**Reviewed By:** Riley, Ken

QA Reviewer